

Work Order ID 61991

Page 1

Wednesday, September 15, 2010 9:48:38 AM

Item ID: D3910-3

Accept



Setup Start



Revision ID:

Item Name: Crosstube Lug

Stop



Start Date: 9/14/2010 Start Qty: 6.00



Cust Item ID:

Required Date: 9/21/2010 Req'd Qty: 6.00



Customer:

Reference:

Approvals: Process Plan:



Date: 10/09/15 Tooling:

Date:

Run Start



QC:

Date: SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D3910

B

100

0.00



Bandsaw

Jeaspa Bandsaw

Memo

Cut to 1.450" Long

0.00

M.A 10/09/27

6 0

110

0.00



HAAS I

HAAS CNC vertical machine #1

Memo

MACHINE AS PER FOLIO FA865 AND DWG

FOLIO REV: AA

DWG REV: B

0.00

28 10/09/08

6 8

DEBURR



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Date:

Tooling:

Date:

Run

Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120



QC2- Inspect parts off machine FAI/FAIB

0.00

88 10/9/28

QC

Quality Control

130



QC8- Inspect parts - second check

0.00

10 10.9.27

QC

Quality Control

140



Chemical Conversion Coat per QSI005 4.1

0.00

88 10-9-30

HandFinish

Hand Finishing

Memo

0.00

D. S.

W/O:		WORK ORDER CHANGES							
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Customer:

Reference:

Approvals: Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start



QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

Sequence ID/
Work Center ID

150



Powdercoat

Powder Coating

Operation
Description

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

M115291 START 10:25
Memo QWEST. 3200
Finish 10:55

Set Up/
Run Hours

0.00

0.00

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160



QC

Quality Control

QC3- Inspect Part Finish

0.00

7/11 10-10-4

6

d

0.00

170



Packaging

Packaging

Identify as per dwg & Stock Location: 507

0.00

Memo

0.00

Property (6)

W/O:		WORK ORDER CHANGES					
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Required Date: 9/21/2010 Req'd Qty: 6.00



Customer:

Reference:

Approvals: Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run

Start



QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

180



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

10/10/05 AD

C21010105

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NOTE: Date & initial all entries

Picklist Print

Page 1

Wednesday, September 15, 2010 9:48:43 AM

Work Order ID: 61991



Parent Item: D3910-3



Parent Item Name: Crosstube Lug

Start Date: 9/14/2010

Required Date: 9/21/2010

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP REV:A NEW ISSUE 09-11-25 JLM VERIFIED BY:DD
REV:B AS PER REV B 10-03-23 JLM VERIFIED BY:DD

IPP

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2423 		Manufactured	No			100	f	364.5171	0.13	0.821053 			

Lug Extrusion

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
MAT06	364.5170795	
43722	180	
45800	184.517079	

0.8210 ft 10/09/27

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	<u>61999</u>
Description: Crosstube Lug	Part Number:	D3910-3
Inspection Dwg: D3910 Rev: B		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

Measured by: <i>SF</i>	Audited by: <i>AA</i>	Preliminary Approval:
Date: 10/09/25	Date: 10 - 9 - 29	Date:

Rev	Date	Change	Revised by	Approved
A	10.04.20	New Issue	KJ	 

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

8 7 6 5 4 3 2 1

D

D

C

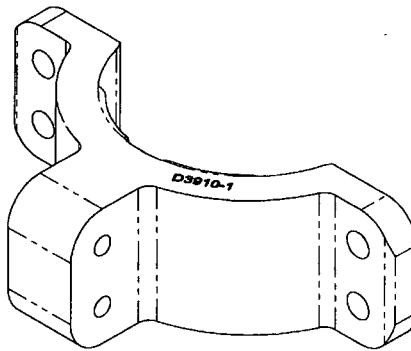
C

B

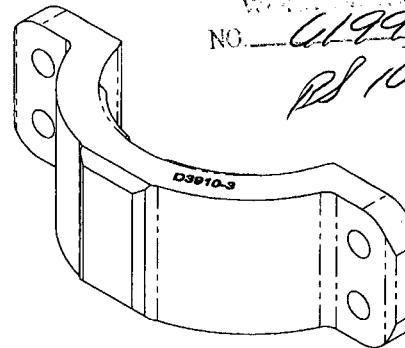
B

A

A



D3910-1 X-TUBE LUG



D3910-3 X-TUBE LUG

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WHEN NEEDED
WHEN NEEDED
NO. *61991*
PS 10-9-15

NOTES:
1) MATERIAL: MAKE FROM D2423 EXTRUSION
2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: ENGRAVE PART NUMBER TO A DEPTH OF 0.010 ± 0.005 IN THIS LOCATION WITH A TOOL TIP RADIUS
OF 0.015 ± 0.005
7) WEIGHT -1: 0.32 lbs
-3: 0.25 lbs

B	$\varnothing 0.257$ HOLES: 4 PL WAS 2 PL (A3-2) & (A3-3); R0.34 FILLET WAS R0.50 (A3-2) & (A3-3). REASON: SEE TR-D350-607-2		JPH	10.03.16
A	NEW ISSUE		JPH	10.03.04
REV.	DESCRIPTION		BY	DATE
DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
DRAWN	JPH	DRAWING NO.	D3910	REV. B SHEET 1 OF 3
CHECKED	1A	MFG. APPR.	<i>[Signature]</i>	
APPROVED	<i>[Signature]</i>	DE APPR.	<i>[Signature]</i>	TITLE X-TUBE LUG (350) SCALE NTS
DATE	10.03.16			COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS RELEASED UNDER THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OTHER THAN THAT FOR WHICH IT WAS RELEASED, OR SHOWN TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

8 7 6 5 4 3 2 1

A

A

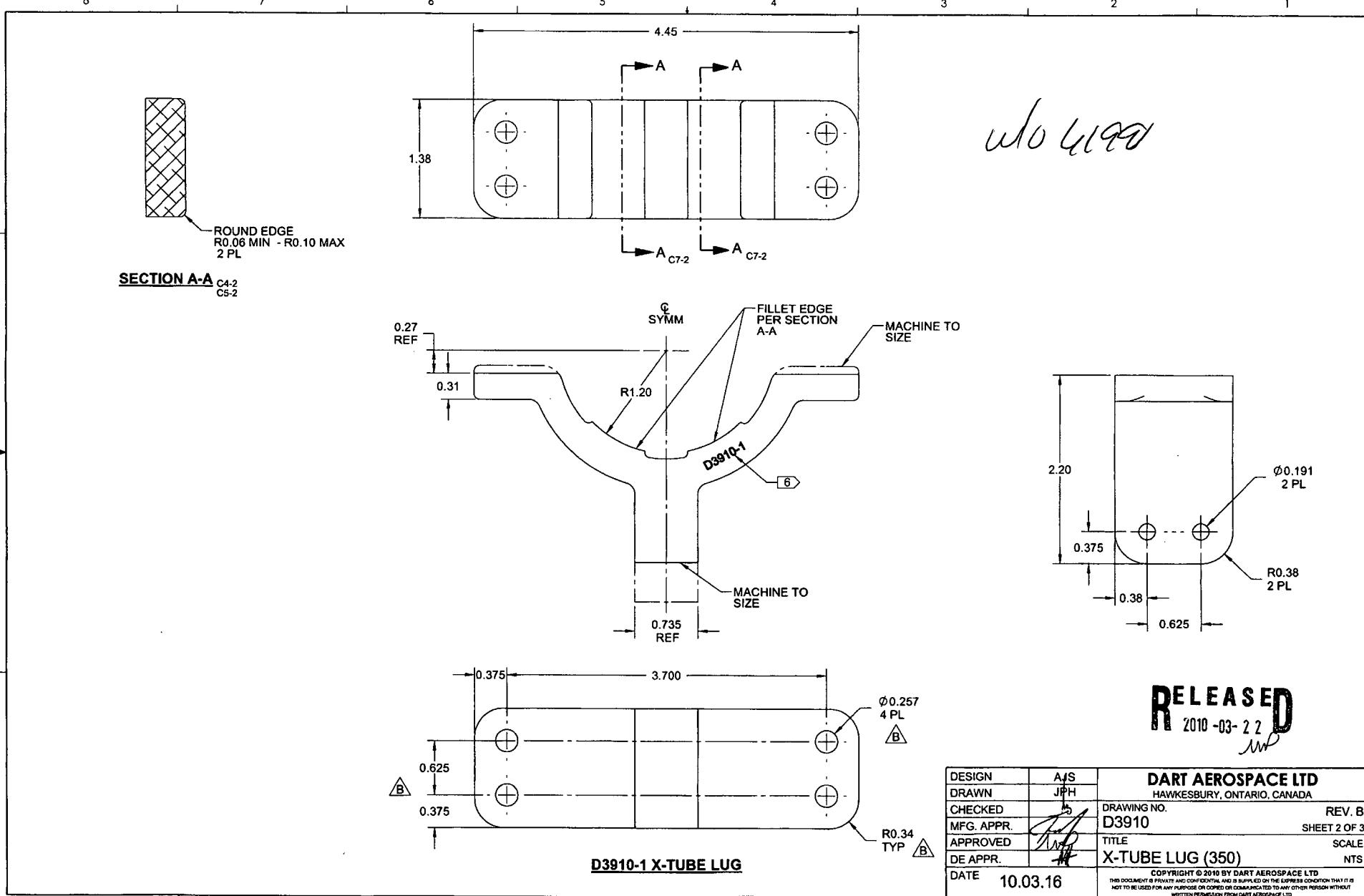
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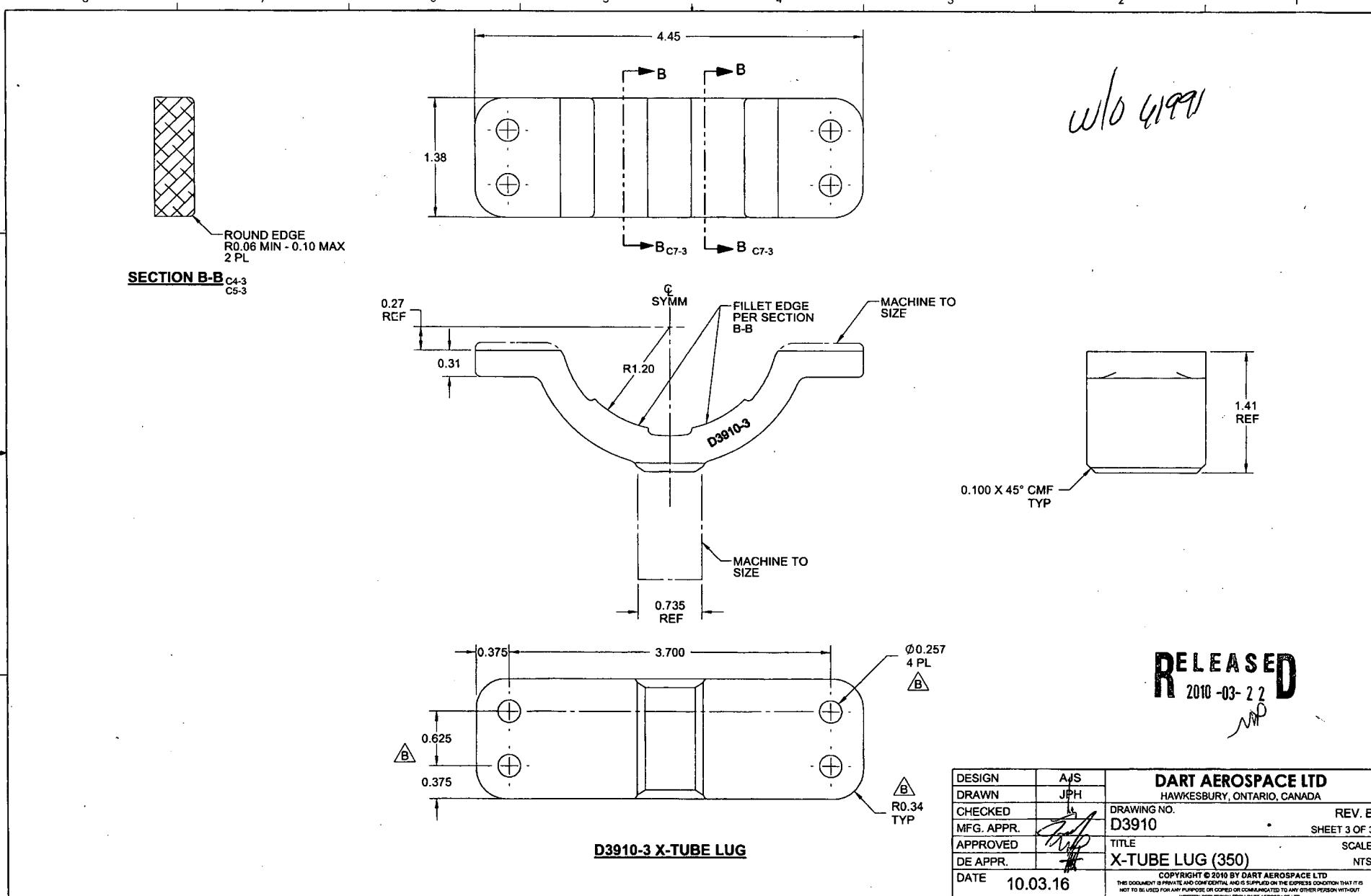


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DESIGN	A/S	DART AEROSPACE LTD
DRAWN	JPH	HAWKSLEY, ONTARIO, CANADA
CHECKED	11	DRAWING NO.
MFG. APPR.		D3910
APPROVED		REV. B
DE APPR.		SHEET 3 OF 3
DATE	10.03.16	TITLE
		X-TUBE LUG (350)
		SCALE
		NTS

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